

# PATENT ABSTRACTS OF JAPAN

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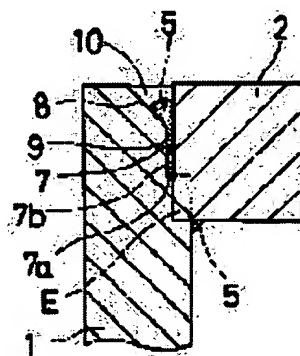
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## (54) WELDING METHOD

(57)Abstract:

**PROBLEM TO BE SOLVED:** To provide a welding method capable of improving productivity by controlling the swelling of an excess wall.

**SOLUTION:** An annular step part 7 is formed in the inner peripheral side of one end part in a tube 1, a gap 9 is formed between a side wall 7b of the step part 7 and a cap which is placed on a bottom surface part 7a of the step part 7. Further, an annular notch part 8 is formed in the end part of the tube 1, and a first and second electrodes are electrically energized while compressing the cap 2 against the tube 1. The excess wall 5 is guided into the gap 9, most of the excess wall 5 escapes into a widening part 10 side. Therefore, the excess wall 5 swelling into the inside of the tube 1 becomes extremely little. The widening part 10 is formed by providing the notch part 8, a large quantity of excess wall 5 is allowed to house in the widening part 10, and whereby the excess wall 5 is controlled to swell out of one end part in the tube 1. Thus, an excess wall shaving process is unnecessitated, whereby productivity is improved that much.



## LEGAL STATUS

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